

Date: Tuesday, 12/20/2005 2:50:19 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER DECKPLATE 350
Job Number	: 25294		
Estimate Number	: 10357		
P.O. Number	: N/A	Part Number	: D2344
This Issue	: 12/20/2005 S.O. No. : N/A	Drawing Number	: D2344 REV.E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 1/15/2006 Qty: 10 Um: Each
Checked & Approved By	: SEE ABOVE USER		
Comment	: Est Rev:D 00.06.26 Removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.7823 sf(s)/Unit Total : 7.8225 sf(s)  
 Material: 2024-T3 QQ-A-250/5) .063  
 Batch *M19059*

*En 06/02/06*

2.0	SHEAR	SHEAR
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Comment: Shear blanks: 17.100" X 6.380" +0.015/-0.000

*En 06/02/06*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Haas #1  
 Machine per folio D2344 & dwg D2344

*J.L 06.02.06 10*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L 06.02.06 10*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*BF 06.02.06 10*

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE-1
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Comment: SMALL/MED FAB

1-Deburr sharp edges *SAD 06302215 -10*

2-Countersink holes per Dwg D2344

*SB 06/02/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 06/02/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 2:50:20 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 25294

Part Number: D2344

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



*06-02-21*

Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*FC 06 02 21*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m 06 02 22 10*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: *51 171*

*06/2/22 10*

11.0

DC

DOCUMENT CONTROL



Comment: Inspection Level 21

*19*  
*06/02/23*

Job Completion



*u 06-02-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	25294
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b>	D2344
<b>Inspection Dwg:</b> D2344 <b>Rev:</b> E		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

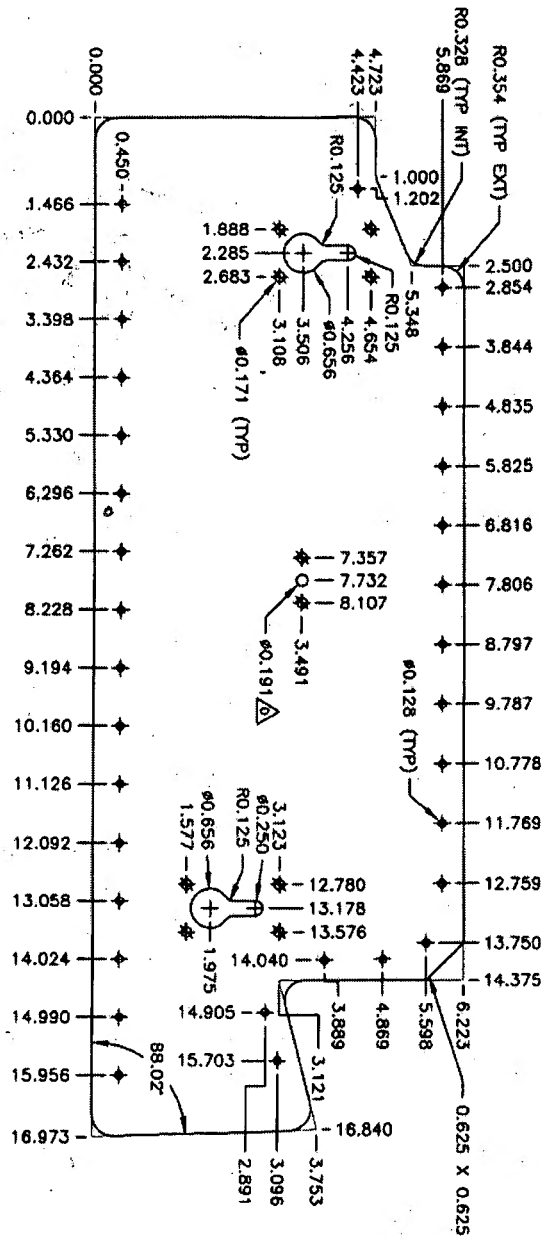
☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.991	+/-0.005	.991	✓			
6.223	+/-0.010	6.222	✓			
5.598	+/-0.010	5.597	✓			
4.869	+/-0.010	4.869	✓			
3.889	+/-0.010	3.889	✓			
3.096	+/-0.010	3.096	✓			
2.891	+/-0.010	2.891	✓			
16.973	+/-0.010					can't measure
0.966	+/-0.005					
0.450	+/-0.010	.450	✓			
4.423	+/-0.010	4.423	✓			
4.723	+/-0.010	4.723	✓			
1.202	+/-0.010	1.202	✓			
5.869	+/-0.010	5.868	✓			
4.654	+/-0.010	4.654	✓			
Ø0.656	+0.005/-0.000	.655	✓			
1.888	+/-0.010	1.888	✓			
2.285	+/-0.010	2.285	✓			
2.683	+/-0.010	2.682	✓			
Ø0.171	+0.005/-0.000	.174	✓			
0.750	+/-0.005	.750	✓			
3.491	+/-0.010	3.491	✓			
Ø0.191	+0.005/-0.000	.192	✓			
0.796	+/-0.005	.796	✓			
3.123	+/-0.010	3.123	✓			
1.527	+/-0.010					can't find
1.975	+/-0.010	1.975	✓			

<b>Measured by:</b> J.L.	<b>Audited by:</b> En	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06-02-06	<b>Date:</b> 06/02/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM

COUNTER SINK HOLES:  
 ◆ C'SINK Ø0.225 x 100°  
 ◆ C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK  
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	KE	98.06.19	A	95.01.14	NEW ISSUE
CHECKED	APPROVED	KE	98.06.19	B	95.02.09	MOVED KEY HOLES
		KE	98.06.19	D	95.03.06	0.191 WAS 0.197
		KE	98.06.19	E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)

RELEASED 12/10/22



